

# Work Order ID 79006

Wednesday, January 18, 2012 11:30:32 AM

**\*79006\***

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Item ID: D407-667-205

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Aft

Stop

**\*NS2\***

Start Date: 1/18/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/18/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: QC21

Approvals: Process Plan: MF

Date: 12-01-18

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D407-667-245	Rev F/DEO								

290

QC5- Inspect part completeness to step on W/O

0.00

**\*290\***

QC

Quality Control

Memo

0.00

*Sizbules*

*CH*

PULL FROM STOCK D407-667-205 B 72743  
UPON SHIPMENT, IT WAS REALIZED THAT QC21 WAS NOT DONE. W/O  
IS CLOSED SINCE BED OF NOVEMBER BUT CAN'T FIND W/O.

QC WILL INSPECT AND ENSURE EVERYTHING COMPLIES.

*QC CH7008*

ATTACHED IS WORK ORDER SUMMARY WHICH SHOWS WHAT HAS  
BEEN PULLED AND WHO COMPLETED THE OPERATIONS

CLOSE UNDER NEW BATCH NUMBER  
NEW LABELS REQU'D

300

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*300\***

Packaging

Memo

0.00

Packaging

*12/1/12*

# Work Order ID 79006

\*79006\*

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Wednesday, January 18, 2012 11:30:32 AM

Item ID: D407-667-205 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Crosstube Aft  
 Start Date: 1/18/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 1/18/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: QC21

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	QC21- Final Inspection - Work Order Release	0.00							
*310*									
QC	Memo	0.00							
Quality Control									

12/1/18 [Signature]

ME 12-01-08

# Work Order Summary

Wednesday, January 18, 2012 11:36:21 AM

REFERENCE ONLY

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Criteria : Work Order ID: 72743 Item ID: D407-667-205 Product Family CROSSTUBES  
 Work Order Start Dates 8/11/2011 to 8/11/2011 11:59:59 PM Work Order Required Dates 8/31/2011 to 8/31/2011 11:59:59 PM  
 All References  
 Work Order Status Costed

<b>Work Order ID</b>	72743	<b>Required Qty</b>	1.0000	<b>Status Code</b>	Costed
<b>Item ID</b>	D407-667-205	<b>Accepted Qty</b>	1.0000	<b>Scrap Qty</b>	0.0000
<b>Item Name</b>	Crosstube Aft				
<b>Current Acct Value</b>	\$3,244.481				
<b>Start Date</b>	8/11/2011	<b>Required Date</b>	8/31/2011	<b>Completed Date</b>	11/4/2011 3:25:19 PM

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
<b>Material</b>	\$1,327.677	\$1,327.677	\$1,278.692	(\$48.985)	-3.83%
<b>Labor</b>	\$562.480	\$562.480	\$410.737	(\$151.743)	-36.94%
<b>Outplant</b>	\$60.583	\$60.583	\$70.100	\$9.517	13.58%
<b>Variable Burden</b>	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>Fixed Burden</b>	\$1,305.560	\$1,305.560	\$881.200	(\$424.360)	-48.16%
<b>Material Burden</b>	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>** Total **</b>	\$3,256.300	\$3,256.300	\$2,640.729	(\$615.571)	

<u>Item ID/Item Name</u>	<u>Required Qty</u>	<u>Issue Code</u>	<u>Issue Date</u>	<u>Issued Qty</u>	<u>Cost Amount</u>
<u>PO ID</u>	<u>PO-Line Nbr</u>	<u>PO Receiver Date</u>	<u>Domestic Unit Price</u>	<u>PO Receipt Qty</u>	<u>Domestic Received Amt</u>
<u>Certification Standard</u>					
Bolt					
<b>PO Rout Seq ID</b>	<b>PO Vendor ID</b>	<b>VC-ACU002</b>			
AN5-10A	10.0000		11/3/2011	10.0000	\$1.432
Bolt					
AN5-34A	7	10/28/2011 9:12:44 AM	\$58.4583	1.0000	\$58.458
Bolt					
	4.0000		11/3/2011	4.0000	\$2.345
	4.0000		11/3/2011	4.0000	\$2.208
D2873-043					
Nut Plate Assembly					
	2.0000		11/4/2011	2.0000	\$56.247
D2873-045					
Nut Plate Assembly					
	2.0000		11/4/2011	2.0000	\$66.194
D2894-1					
2.750 Support					
	1.0000		11/4/2011	1.0000	\$482.085
D3190-1					
Chafing Shield					
	2.0000		11/4/2011	2.0000	\$17.287
D3595-063-450					
RUBBER CUSHION					
	2.0000		11/4/2011	2.0000	\$1.095
D407-667-205TRN					
Crosstube Turning Detail					
	1.0000		10/20/2011	1.0000	\$1,607.864
MS20601-AD4W8					
RIVET					
	14.0000		11/4/2011	14.0000	\$6.775

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Work Order Summary

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MS21042L5

Nut

4.0000

11/3/2011

4.0000

\$1.758

MS21920-22

Clamp(per MIL-DTL-8783C)

4.0000

11/4/2011

4.0000

\$54.568

MS21920-25

Clamp(per MIL-DTL-8783C)

2.0000

11/4/2011

2.0000

\$60.955

NAS1149D0563J

Washer

18.0000

11/4/2011

18.0000

\$1.098

Total Matl Amts: \$2,361.910

Invoice Rout Seq ID

Invoice Vendor ID

vc-acu002

Invoice ID

Invoice Line Nbr

Invoice Date

Invoice Unit Price

Invoice Qty

Invoice Amt

0000090671

7

11/15/2011 10:50:33  
AM

60.583333

1.0000

\$60.583

Work Center CNC Bend 1

Employee ID

Rout Seq ID

Labor  
DateSetup  
HoursActual  
Setup  
HoursLabor  
HoursActual  
Labor  
HoursNbr  
of  
WOsSetup  
AmountLabor  
AmountFix Burd  
AmountVar Burd  
AmountTotal  
Amounts

drou02

10/19/2011

120

0.84

0.42

0.00

0.00

2.00

\$9.066

\$0.000

\$18.010

\$0.000

\$27.076

10/20/2011

120

0.00

0.00

1.23

1.23

1.00

\$0.000

\$26.617

\$52.877

\$0.000

\$79.493

PAQU03

10/19/2011

120

0.00

0.00

0.51

0.25

2.00

\$0.000

\$5.467

\$10.860

\$0.000

\$16.327

10/20/2011

120

0.00

0.00

1.44

1.44

1.00

\$0.000

\$31.105

\$61.793

\$0.000

\$92.897

Total:

0.84

0.42

3.17

2.92

6.00

\$9.066

\$63.188

\$143.539

\$0.000

\$215.793

Work Center Crosstubes

Employee ID

Rout Seq ID

Labor  
DateSetup  
HoursActual  
Setup  
HoursLabor  
HoursActual  
Labor  
HoursNbr  
of  
WOsSetup  
AmountLabor  
AmountFix Burd  
AmountVar Burd  
AmountTotal  
Amounts

ouim01

10/26/2011

140

0.00

0.00

0.79

0.79

1.00

\$0.000

\$14.779

\$37.153

\$0.000

\$51.932

titl01

10/25/2011

140

0.00

0.00

2.91

1.45

2.00

\$0.000

\$27.352

\$68.758

\$0.000

\$96.110

11/1/2011

230

0.00

0.00

0.19

0.10

2.00

\$0.000

\$1.804

\$4.535

\$0.000

\$6.339

230		0.00	0.00	0.68	0.34	2.00	\$0.000	\$6.406	\$16.104	\$0.000	\$22.511
11/2/2011											
230		0.00	0.00	0.86	0.43	2.00	\$0.000	\$8.134	\$20.447	\$0.000	\$28.581
230		0.00	0.00	2.61	1.31	2.00	\$0.000	\$24.604	\$61.851	\$0.000	\$86.455
230		0.00	0.00	0.44	0.22	2.00	\$0.000	\$4.161	\$10.460	\$0.000	\$14.621
230		0.00	0.00	2.73	1.37	2.00	\$0.000	\$25.692	\$64.585	\$0.000	\$90.277
11/3/2011											
230		0.00	0.00	1.99	1.00	2.00	\$0.000	\$18.729	\$47.081	\$0.000	\$65.809
<b>Total:</b>		0.00	0.00	13.21	7.00	17.00	\$0.000	\$131.662	\$330.974	\$0.000	\$462.635

#### Work Center HandFXtube

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ouim01												
10/26/2011												
150			0.00	0.00	0.49	0.49	1.00	\$0.000	\$9.211	\$23.154	\$0.000	\$32.364
<b>Total:</b>			0.00	0.00	0.49	0.49	1.00	\$0.000	\$9.211	\$23.154	\$0.000	\$32.364

#### Work Center SprayPaint

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
titl01												
10/28/2011												
210			0.00	0.00	2.31	1.15	2.00	\$0.000	\$21.690	\$54.525	\$0.000	\$76.215
10/29/2011												
210			0.00	0.00	1.16	0.58	2.00	\$0.000	\$10.879	\$27.348	\$0.000	\$38.226
210			0.00	0.00	0.52	0.13	4.00	\$0.000	\$2.440	\$6.134	\$0.000	\$8.574
<b>Total:</b>			0.00	0.00	3.98	1.86	8.00	\$0.000	\$35.009	\$88.006	\$0.000	\$123.015

## 5.0 PARTS LIST

## 5.1 HIGH GEAR CROSSTUBES

Item	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
		X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
			X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
				X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
					X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
						X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1	1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2		1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3			1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4				1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5					1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6						1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10	*2	*2	*2		*2		D2891-1	SUPPORT
11				*2			D2892-1	SUPPORT
12						*1	D2894-1	SUPPORT
13	*4	*4	*4		*4		D3595-063-395	RUBBER CUSHION
14				*4			D3595-063-450	RUBBER CUSHION
15						*2	D3595-075-430	RUBBER CUSHION
16	*4	*4	*4		*4		MS21920-20	CLAMP
17				*4		*4	MS21920-22	CLAMP
18						*2	MS21920-25	CLAMP (OR MS21920-24)
19	4	4	4		4		AN5-32A	BOLT
20				4		4	AN5-34A	BOLT
21	4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	8	8	8	8	NAS1149C0563J	WASHER (OR AN960JD516)
23						*2	D3190-1	CHAFING SHIELD
40	*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41	*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42		2					D2872-043	NUT PLATE
43		2					D2872-045	NUT PLATE
44	10		10				AN5-7A	BOLT
45		10		10	10	10	AN5-10A	BOLT
46	4	10	4		4		AN5-30A	BOLT
47				4		4	AN5-32A	BOLT
48			12				AN970-4	WASHER (OPTIONAL)
49		6					MS21042L5	NUT (OR MS21042-5)
50	10	12	10	10	10	10	NAS1149C0563J	WASHER (OR AN960JD516)
60		1					D3039-3	CENTER DRILL (TOOLING, NOT INSTALLED)

\*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/-143/-241/-243 & D407-667-145/-245  
ASSEMBLIES ABOVE

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